

WPP PP PPH5CF3-Black

Polypropylene Homopolymer
Washington Penn Plastic Co. Inc.

Message:
Properties shown below for this filled blend are typical for a 33% calcium carbonate filled polypropylene homopolymer.

General Information			
Filler / Reinforcement	Calcium carbonate filler, 32% filler by weight		
Additive	heat stabilizer		
Features	Good dimensional stability		
	Rigid, good		
	Homopolymer		
	Impact resistance, good		
	Thermal Stability		
Uses	Application in Automobile Field		
	Consumer goods application field		
Appearance	Black		
	Available colors		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	18	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	19.0	MPa	ISO 527-2/5
Flexural Modulus ¹	2350	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-40°C	3.5	kJ/m ²	ISO 179
23°C	4.8	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	65.0	°C	ISO 75-2/A
Additional Information			
Tested at 23 ± 2°C (73.4 ± 3.6°F) and 50 ± 5% relative humidity unless otherwise noted.			
Injection	Nominal Value	Unit	
Drying Temperature	71.1 - 87.8	°C	
Drying Time	1.0	hr	

Rear Temperature	216 - 221	°C
Middle Temperature	216 - 221	°C
Front Temperature	218 - 224	°C
Nozzle Temperature	224 - 235	°C
Mold Temperature	15.6 - 48.9	°C
Injection Pressure	4.14 - 7.58	MPa
Holding Pressure	1.72 - 4.83	MPa
Back Pressure	0.517 - 1.03	MPa
Clamp Tonnage	3.4 - 5.5	kN/cm ²
Cushion	3.18 - 6.35	mm

Injection instructions

Injection Speed: 1.5 to 2.5 in/s Zone 4 Temperature: 435 to 445°F Hot Runner Temperature: 435 to 465°F Hydraulic Oil Temperature: 110 to 125°F Shot Capacity vs. Barrel Capacity: 2.5 to 4 Screw Decompression: 0.1 to 0.25 in

NOTE

1. 2.0 mm/min

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